

Date: Thursday, 6/21/2007 2:29:31 PM  
User: Kim Johnston

## **Process Sheet**

|  |   |  |                  |                       |  |
|--|---|--|------------------|-----------------------|--|
| Customer   | : CU-DAR001 Dart Helicopters Services                                   |  | Drawing Name     | : FUEL PURGE CANISTER |  |
| Job Number   | : 33065A  |  |                  |                       |  |
| Estimate Number  | : 10441   |  |                  |                       |  |
| P.O. Number  | : N/A   |  | Part Number      | : D32621              |  |
| This Issue   | : 6/21/2007 S.O. No. : N/A  |  | Drawing Number   | : D3262 REV C         |  |
| Prsht Rev.   | : NC  |  | Project Number   | : N/A                 |  |
| First Issue  | : N/A   |  | Drawing Revision | : C                   |  |
| Previous Run   | : 32261A  |  | Material         | : N/A                 |  |
| Written By   |   |  | Due Date         | : 7/15/2007           |  |
| Checked & Approved By  |   |  | Qty:             | 6 Um: Each            |  |
| Comment  | : Est. C 05.03.10 Removed P/O for liquid penetrant inspection K<br>JJLM |  |                  |                       |  |
| <b>Additional Product</b>  |   |  |                  |                       |  |
| Job Number:  |   |  |                  |                       |  |
| Seq. #:  | Machine Or Operation:   | Description :                          |                  |                       |  |
| 1.0  | M6061T6T5000W125  | 6061-T6 Tube 5.00X.125W                |                  |                       |  |
| Comment: Qty.: 0.9406 f(s)/Unit Total : 5.6435 f(s)<br>Material: 6061-T6 (QQ-A-200/8 or 225/8) 5.00 OD x 0.125" wall (M6061T6T5.000W.125)<br>Identify as D3262-1<br>Batch: <u>i02019</u> SC 07.09.02 |   |  |                  |                       |  |
| 2.0  | BAND SAW  | BAND SAW                               |                  |                       |  |
| Comment: BAND SAW<br>Cut D3262-1 to length as per Dwg D3262<br>Identify as D3262-1  SC 07.09.02 6  |   |  |                  |                       |  |
| 3.0  | SMALL FAB 1   | SMALL & MEDIUM FAB RESOURCE 1          |                  |                       |  |
| Comment: SMALL & MEDIUM FAB RESOURCE 1<br>Deburr  SC 07.09.02 6  |   |  |                  |                       |  |
| 4.0  | QC2   | INSPECT PARTS AS THEY COME OFF MACHINE |                  |                       |  |
| Comment: INSPECT PARTS AS THEY COME OFF MACHINE  SC 07.09.02 6   |   |  |                  |                       |  |
| 5.0  | QC8   | SECOND CHECK                           |                  |                       |  |
| Comment: SECOND CHECK  SC 07/09/03 6   |   |  |                  |                       |  |

| W/I/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|--------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE   | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|        |      |                    |    |      |     |                                     |                          |
|        |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA:  Date: 5/10/05  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FUEL PURGE CANISTER

Job Number: 33065A

Part Number: D32621

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 57164

P 7/9/05 (4)

7.0 QC21

FINAL INSPECTION/W/O RELEASE



(6)

Comment: FINAL INSPECTION/W/O RELEASE

P 07/09/05

Job Completion



W 07/09/05

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries

|                       |              |             |
|-----------------------|--------------|-------------|
| DART AEROSPACE LTD    | Work Order:  | 33065A      |
| Description: Tube     | Part Number: | D3262-1     |
| Inspection Dwg: D3262 | Rev: C       | Page 1 of 1 |

# FIRST ARTICLE INSPECTION CHECKLIST

## X First Article      Prototype

|              |                    |             |                    |                     |     |
|--------------|--------------------|-------------|--------------------|---------------------|-----|
| Measured by: | <i>[Signature]</i> | Audited by: | <i>[Signature]</i> | Prototype Approval: | N/A |
| Date:        | 07-09-03           | Date:       | 07/09/03           | Date:               | N/A |

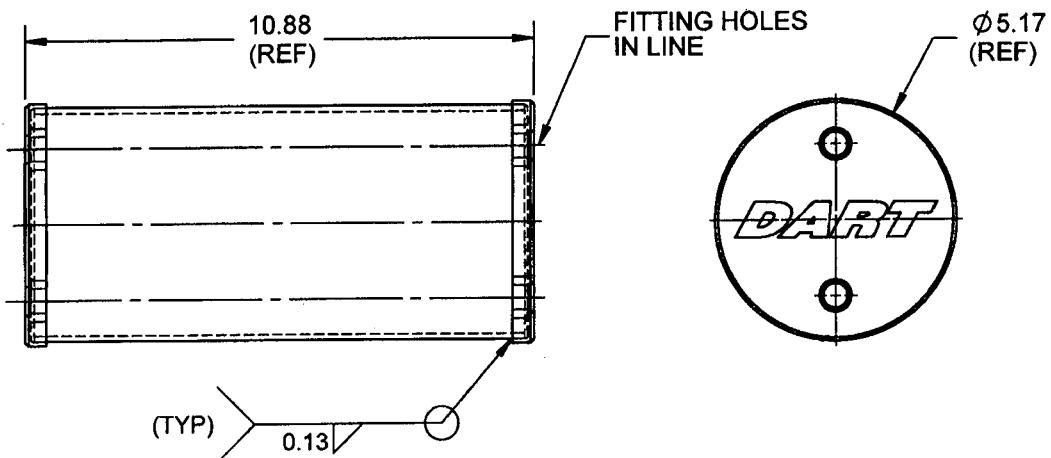
| Rev | Date     | Change                | Revised by | Approved |
|-----|----------|-----------------------|------------|----------|
| A   | 06.05.24 | New Issue             | KJ/JLM     |          |
| B   | 06.12.14 | Dwg updated to Rev. C | KJ/JLM     | Z        |

**DART**

|                      |                       |   |
|----------------------|-----------------------|---|
| DESIGN<br><i>RF</i>  | DRAWN BY<br><i>JB</i> | DART AEROSPACE LTD<br>HAWKESBURY, ONTARIO, CANADA |
| CHECKED<br><i>PH</i> | APPROVED<br><i>HF</i> | DRAWING NO.<br>D3262                              |
| DATE<br>06.08.31     |                       | TITLE<br>FUEL PURGE CANISTER                      |
|                      |                       | SCALE<br>1:4                                      |
| REV                  | DATE                  | DESCRIPTION                                       |
| A.                   | 04.05.06              | FIRST ISSUE                                       |
| B                    | 05.02.14              | ADD PRESSURE TESTING OPTION                       |
| C                    | 06.08.31              | Ø5.165 WAS Ø5.190                                 |

RELEASED

06.09.19 *HF*

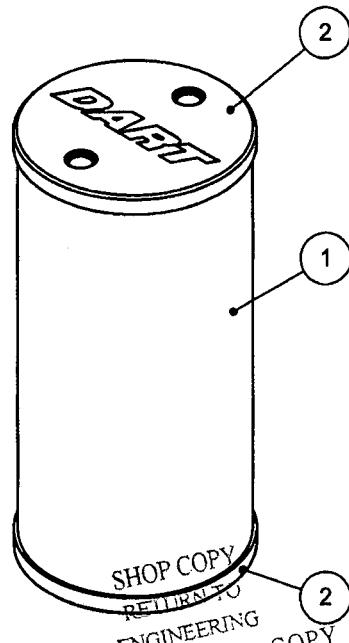


### D3262-041 CANISTER ASSEMBLY

| ITEM | QTY<br>-041 | P/N       | DESCRIPTION       |
|------|-------------|-----------|-------------------|
|      | X           | D3362-041 | CANISTER ASSEMBLY |
| 1    | 1           | D3262-1   | TUBE              |
| 2    | 2           | D3262-3   | CAP               |

**NOTES:**

- 1) WELD PER DART QSI 004
- 2) BREAK ALL SHARP CORNERS 0.005 TO 0.010
- 3) LIQUID PENETRANT INSPECT PER ASTM E1417 LEVEL 1 OR  
PRESSURIZE TO 10 psi AND SUBMERGE UNDER WATER TO **A**  
CHECK FOR LEAKS
- 4) FINISH: CHEMICAL CONVERSION COAT PER QSI 005 4.1  
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART  
QSI 005 4.3
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 7) IDENTIFY WITH DART P/N AND B/N USING FINE POINT PERMANENT INK MARKER



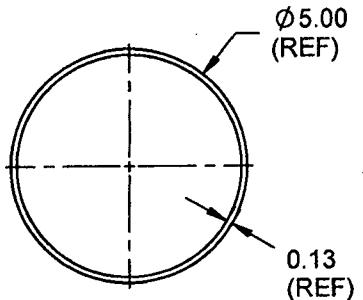
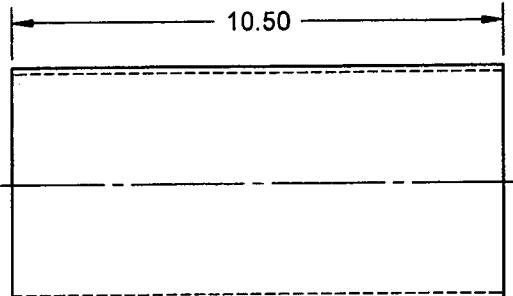
SHOP COPY  
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UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. *33065A*

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**DART**

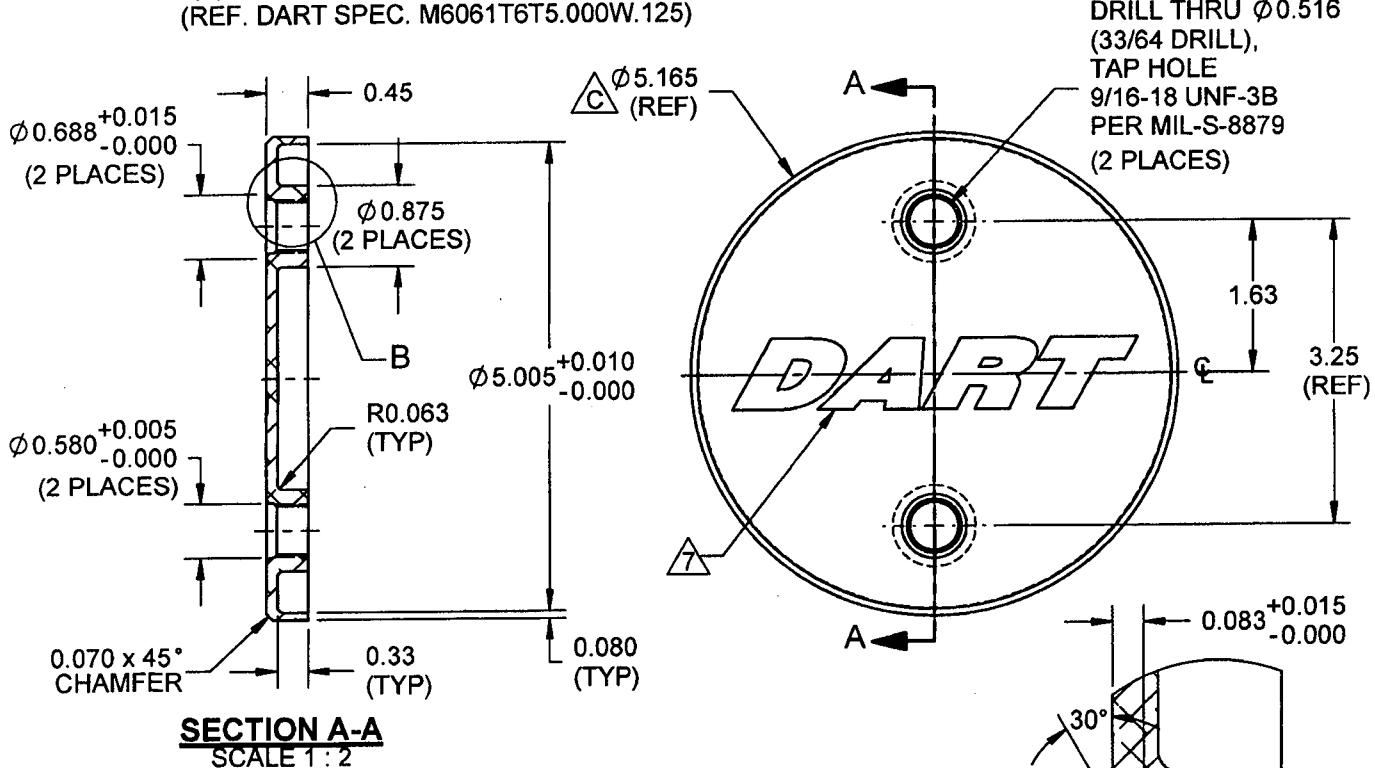
|                      |                              |   |                        |
|----------------------|------------------------------|---|------------------------|
| DESIGN<br><i>RF</i>  | DRAWN BY<br><i>JB</i>        | DART AEROSPACE LTD<br>HAWKESBURY, ONTARIO, CANADA |                        |
| CHECKED<br><i>PH</i> | APPROVED<br><i>JH</i>        | DRAWING NO.<br>D3262                              | REV. C<br>SHEET 2 OF 2 |
| DATE<br>06.08.31     | TITLE<br>FUEL PURGE CANISTER | SCALE<br>1:4                                      |                        |



RELEASED  
*[Signature]*  
06.09.19

**D3262-1 TUBE**

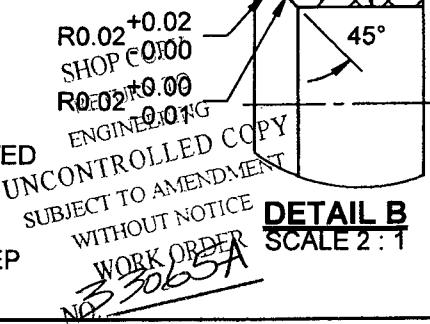
1) MATERIAL: 6061-T6 OR 6061-T62 TUBING, 5.00 OD x 0.125 WALL PER WW-T-700/6 OR AMS 4080 OR AMS 4082 OR QQ-A-200/8 OR QQ-A-225/8 (REF. DART SPEC. M6061T6T5.000W.125)

**D3262-3 CAP**

1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8) BAR (REF. DART SPEC. M6061T6B)

**NOTES:**

2) FINISH: NONE  
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED  
5) BREAK ALL SHARP CORNERS 0.005 TO 0.010  
6) PART IS SYMMETRICAL ABOUT CENTERLINE  
7) ENGRAVE 'DART' LOGO AS SHOWN USING 0.75 HIGH x 0.010 DEEP (MAX) LETTERS WITH TOOL RADIUS OF 0.25 (MIN)



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